



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3254-041
Job Sheet 169523



Part No: D3254-041

Job Qty: 6 ea

Part Name: Side LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/13/17

Job Tracking No:

Due Date: 12/29/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV A IPP B 04.10.26 D3254-1 no longer made in-house IPP Rev:C 11.02.07 made on W.J. DD
verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		12/28/17	0.00	0.00	Start Up Waterjet		SC 18/01/20
100	Waterjet	6 pcs		12/28/17	0.00	2.02	Waterjet1		SC 18/01/20
110	QC	6 pcs		12/28/17	0.00	0.00	QC2 Waterjet-1		SC 18/01/20
120	QC	6 pcs		12/28/17	0.00	0.00	QC8-2		38
130	Brake NC	6 pcs		12/28/17	0.08	0.37	Brake NC 2		DAS 38
140	QC	6 pcs		12/28/17	0.00	0.00	QC5		38
150	HandFinish	6 pcs		12/28/17	0.00	0.60	HandFinish1		19-02-08
151	QC	6 pcs		12/28/17	0.00	0.00	QC3		DAS
153	Small Fab	6 pcs		12/28/17	0.00	0.98	Small Fab-3		38
157	QC	6 pcs		12/28/17	0.00	0.00	QC5		38
170	Powdercoat	6 pcs		12/29/17	0.00	0.30	Powdercoat4		BL 18-2-21
180	QC	6 pcs		12/29/17	0.00	0.00	QC3		38
190	Packaging	6 pcs		12/29/17	0.00	0.00	Packaging3-1		52-17 DAS
200	QC21-SA	6 Ea		12/29/17	0.00	0.00	QC21		6 FEB 22 2018

Part Op 100 - 1-Cut as per Dwg

Descriptions: 153 - Install D3248-1 as per dwg

170 - START TIME: 1.25

FINISH TIME: 1.55 CUT 320°

5029837 ④

M 138700

FEB 22 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M2024T3S.063	38	261	0	0
153-Small Fab	D3248-1 ✓ 5019863 4x	12	4	0	0
	MS20470AD4-5	108	2,908	0	0

FM 136857-2

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS					
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐			
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐			
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐			
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐				

Date : _____ Step #: _____ QTY Effective : _____ MRB (QSI042) Approval _____

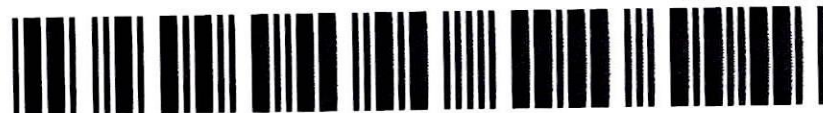
Description Work Order Device

Start up Operation 01/21/18
Job No: 169523
Change No:
Operation:
Revision:
Original Serial #: S034029
PART NO: D3254-041

Completed By

Hand / Supervisor
Approval VerificationQA Coordinator
Approval

Side LH



S034029


Positioned Wrong
Outside Dimensions
Over/Under tolerance
Incorrect
Lost/Missing

Root Cause			Dart Aerospace Ltd.			S034029		
Environment ☐	No Re-verification ☐	Pressure ☐	www.dartaerospace.com			Out of Sequence ☐		
Design ☐	Operator ☐	Bending ☐	Email: sales@dartaero.com			Off-set ☐		
Doc/Data ☐	Offset/Setup ☐	Centre ☐	TEL: 1 613 632-5200			Misabeled ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	CANADA			Fit/Function ☐		
Handling/Pre ☐	Training ☐	Crimp/K ☐	1270 Aberdeen Street			Misaligned/off center ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Hawkesbury, ON K6A 1K7			Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Dart Aerospace Ltd.			Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐				Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐				Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐				Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐							
Misidentified ☐	Past Due ☐	OTHER : _____						

DART AEROSPACE LTD		Work Order: 169523
Description: side dual battery rack		Part Number: D3254-041
Inspection Dwg: D3254	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5,20	+/- 0,030	5,207	1		UDC-02	
4,15	+/- 0,030	4,158	1		T9/R	
R0,19	+/- 0,030	R0,19	1			
1,103	+/- 0,020	1,105	1			
0,300	+/- 0,010	0,302	1			
Ø 0,098	+0,005 - 0,001	Ø 0,100	1			
1,300 pitch	+/- 0,005	1,301	1			
21,050	+/- 0,010	21,057	1			
19,000	+/- 0,010	19,002	1			
1,003	+/- 0,010	1,004	1			
Ø 1,125	+0,005 - 0,001	Ø 1,125	1			
5,403	+/- 0,010	5,404	1			
Ø 1,500	+0,005 - 0,000	Ø 1,500	1			
2,750 Pitch	+/- 0,005	2,750	1			
5,500	+/- 0,010	5,500	1			
1,653	+/- 0,010	1,654	1			
3,75	+/- 0,030	3,758	1			
10,810	+/- 0,010	10,811	1			
8,00	+/- 0,030	8,00	1			
R0,50	+/- 0,030	R0,50	1			
4,125	+/- 0,010	4,126	1			
22,946	+/- 0,010	22,947	1			
9,90	+/- 0,030	9,906	1			

Measured by: SC	Audited by: 38	Preliminary Approval:
Date: 18/01/20	Date: FEB 07 2018	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	